

Date: Thursday, 12/13/2007 11:20:57 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 36298		
Estimate Number	: 10513		
P.O. Number	:	Part Number	: D28052
This Issue	: 12/13/2007 S.O. No. :	Drawing Number	: D2805 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 34033	Material	:
Written By	:	Due Date	: 1/10/2008
Checked & Approved By	: <u>John. 12/13</u>	Qty:	12 Um: Each
Comment	: Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
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Comment: Qty.: 0.2756 f(s)/Unit Total : 3.3075 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch:

B16954 1'  
~~B102773-2~~  
 B102723 2008/2/13

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

J.L. 08/02/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-2

J.L. 08/02/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 08/02/11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L. 08/02/11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/14

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:20:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 36298

Part Number: D28052

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 08-02-12 (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

AS 08/02/13 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST47

AS 08/02/13 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/14 (10)

Job Completion



min 2008/2/13 (10)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

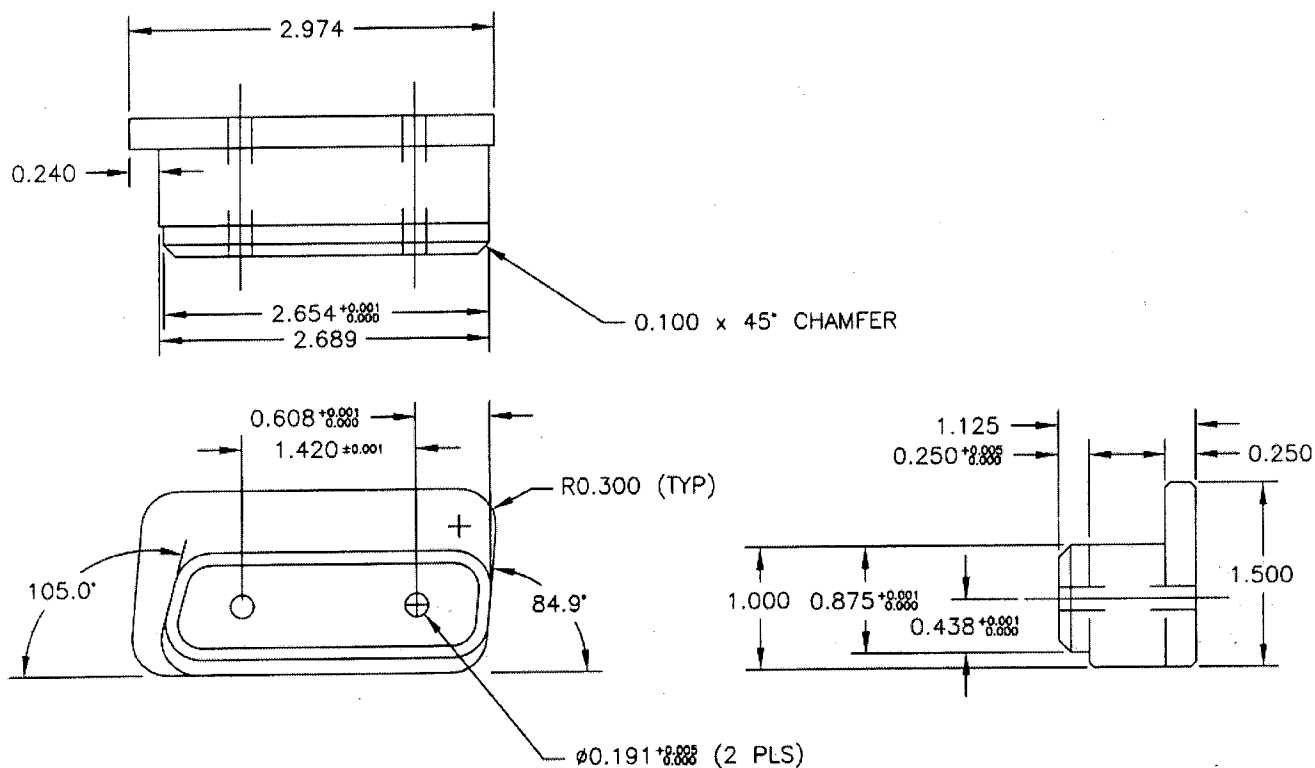
**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED  
01.03.16



D2805-1 (SHOWN)  
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 36298

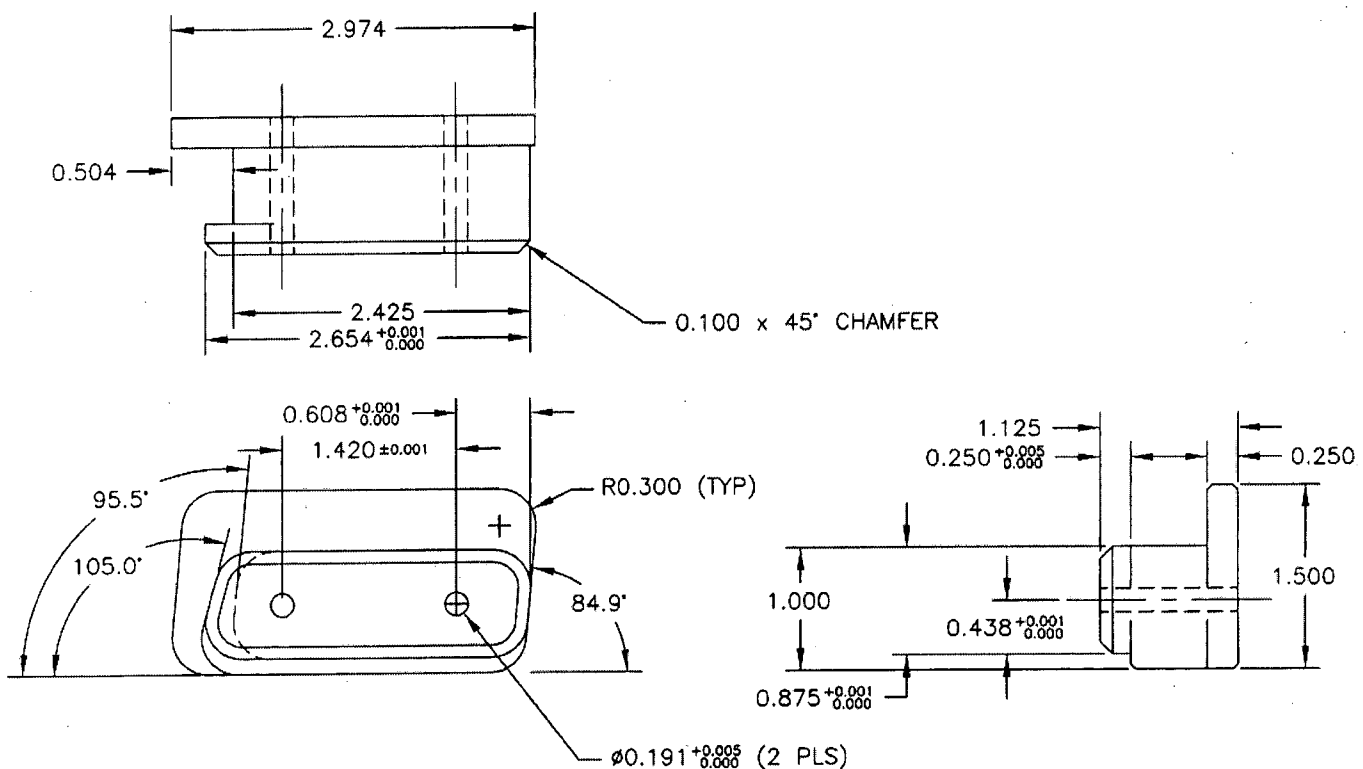
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED  
01.03.16



D2805-3 (SHOWN)  
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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